



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBT18520-1
Job Sheet 186720



Part No: RBT18520-1

Job Qty: 6 ea

Part Name: Lift Device Frame



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/20/18

Job Tracking No:

Due Date: 12/7/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBT18520-1 REV:11 IPP REV A 18.02.07 NEW ISSUE RQ VERIFIED BY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	12/7/18	12/7/18	0.00	0.00	Start Up Waterjet2		12/11/27
100	Waterjet - Flow - B4B	6 pcs	12/7/18	12/7/18	0.08	1.20	Waterjet 2 OMAX		12/11/27
110	QC	6 pcs	12/7/18	12/7/18	0.00	0.00	QC2 Waterjet-4		12/11/27
120	CNC Vertical Machining	6 pcs	12/7/18	12/7/18	1.50	3.00	HAAS 1		J.C.V.
130	QC	6 pcs	12/7/18	12/7/18	0.00	0.00	QC2 Machining-5		J.C.V. 18-12-16
140	QC	6 pcs	12/7/18	12/7/18	0.00	0.00	QC8 Machining-5		D.A. 18-12-17
170	Outsource	6 pcs	12/7/18	12/7/18	GRAPHE		ATG001-VC	10	12-12-12
180	Packaging	6 pcs	12/7/18	12/7/18	0.00	0.00	Packaging2		DEC 18 2018
190	QC	6 pcs	12/7/18	12/7/18	0.00	0.00	QC6		DEC 18 2018
200	Packaging	6 pcs	12/7/18	12/7/18	0.00	0.00	Packaging3-2		DEC 18 2018
210	QC21-SA	6 Ea	12/7/18	12/7/18	0.00	0.00	QC21		DEC 18 2018

Part Op 120 - 1-Machine as per folio FB855 FOLIO REV: 11 DWG REV: 11 2-Deburr 3-Engrave T/N
Descriptions: And / or S/N number as required Using Marktronic engraver as per DWG.

170 - Issue P/O to ATG 0042060 - ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required

180 - Receive

200 - Identify and Stock

RED IS ACCEPTABLE

DEC 20/18 GA145B

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.000X06.000	6061T6 Bar 1.00 X 6.00	6.4980 ft (1.083 ea)	100-Waterjet - Flow - B4B	5123 711

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - B4B	M6061T6B1.000X06.000	6	54	0



Dart Aerospace Ltd.
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Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S132092



Part: RBT18520-1

Job No: 186720

Serial No/Batch: S132092

Revision: 11

Inspector:

Exp Date:

Instructions:

Date: 12/19/18

ons

be found.

Plex 11/20/18 1:31 PM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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800-670-000			800-670-000		Lead hand / Supervisor Approval Verification																																																																
					QC / QA Coordinator Approval																																																																
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Container No: S132092



Part: RBT18520-1

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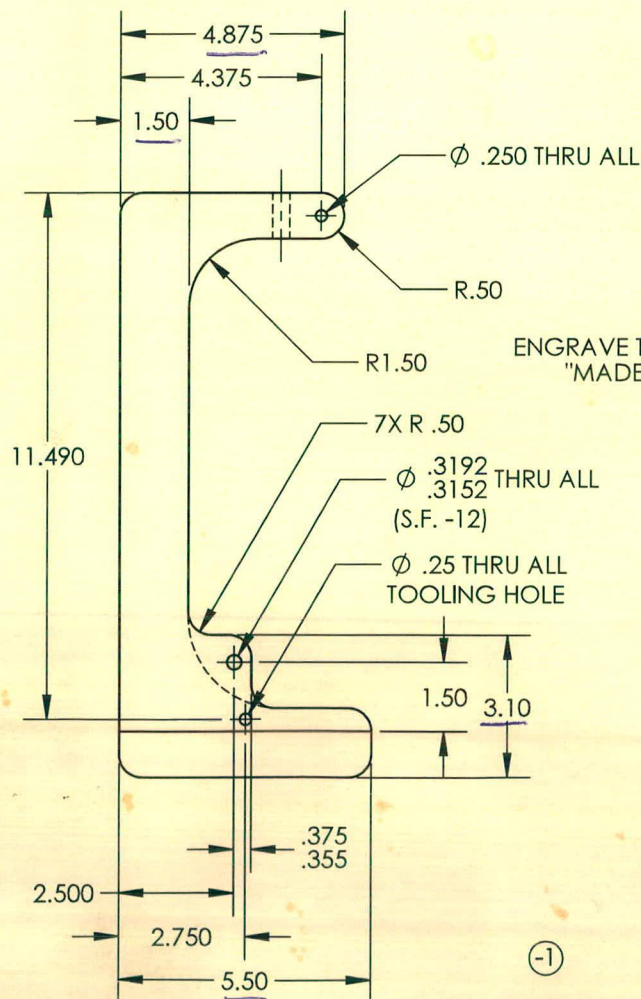
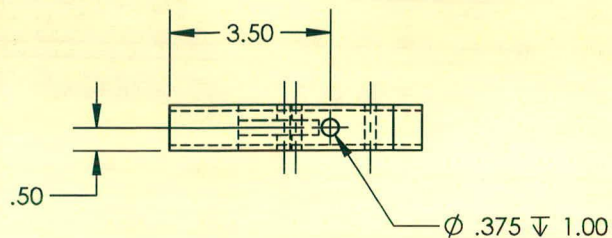
Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 11/26/18

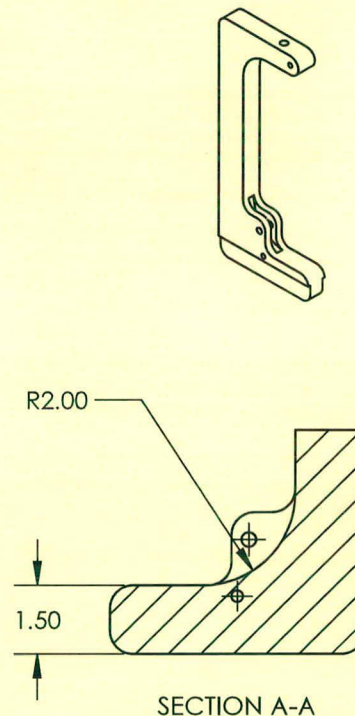
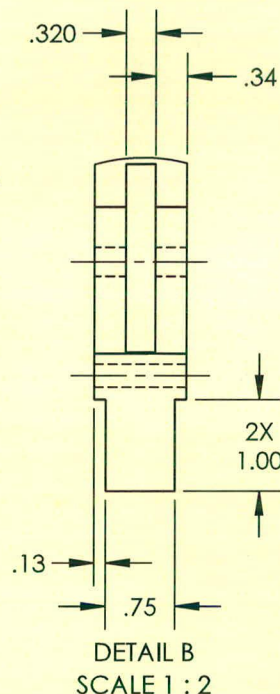
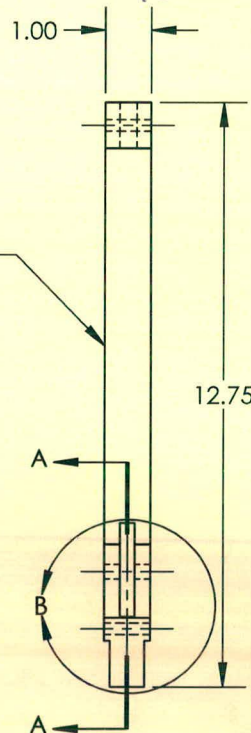
This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS			DATE	INITIAL	APPROVED
REV	ECR	DESCRIPTION			
6		CHANGED -1 PIVOT HOLE FROM Ø.257 TO Ø5/16 REAMED	6/17/2009	WP	G.E.
8A		CH'D Ø.375 REAMED TO THRU PER G.E.	8/24/2010	WP	G.E.
9		-1 ADDED Ø.25 TOOLING HOLE.	8/7/2013	RJC	DW
10	16-0096	-1 CH'D DIMS WAS Ø.375 THRU IS Ø.375 ± 1.00, WAS REAM Ø.3125 IS Ø.3152-.3192 THRU ALL (S.F. -12), WAS 1.00 IS 2X 1.00, WAS (.125) IS .13.	8/4/2016	DPD	JAG

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 186720 MJS
181120



(-1)
FRAME



DART AEROSPACE	
TITLE ROTOR DAMPER TEST DEVICE	
DWG NO. RBT18520-1	REV 11
MAT'L 6061	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .010 FRACTIONS ± 1/8
FINISH BLACK ANODIZE	.XX ± .03 ANGLES ± 1°
SPEC MIL-A-8625F, TYPE II, CLASS II	.X ± .1 SURFACES = 125 ✓
DRAWN BY: COLE	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: MACKOVJAK	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	
SCALE 1:4	DATE 8/17/2000 SHEET 2 OF 17



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO042060

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO042060
PO Date: 12/17/18
Due Date: 12/21/18
**Purchase Order
Revision:**
Revision Date:
Ship-To Contact: Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 60

Freight Terms:
Special Comments: *reused qty,
Signed P.O. below.

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	186720	RBT18520-1	Lift Device Frame -Issue P/O : -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	-	12/21/18	4 pcs	0 pcs	4 pcs	\$30.00/pcs	\$120.00
Grand Total:											\$120.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 12/19/18 9:57 AM dart.tsimiklis.chrisoula

200
200
200



Certificat de Conformité / Certificate of Compliance

(015448-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

015448 - 1

Livré à / Ship to

DART AEROSPACE LTD

1270 ABERDEEN STREET

HAWKESBURY, ON, K6A1K7

CANADA

Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD

1270 ABERDEEN STREET

HAWKESBURY, ON, K6A1K7

CANADA

BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.					
19-Dec-2018		Aman		042060 ✓					
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Quantités / Quantities Qté NC/ NC Qty		Qté Scrap/	À venir / Back Order
1	RBT18520-1 Rev. ✓	RBT18520-1 01 -ANO-BLACK [ANODIZE BLACK] BLACK ANODIZE MIL-A-8625F TYPE 2 CLASS 2	ANODIZE CH	4	4 ✓	0	0	0	0

DAS
38
9-89

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness
Inspecteur Qualité
Quality Inspector
Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.

240
52
18-0